

PCT

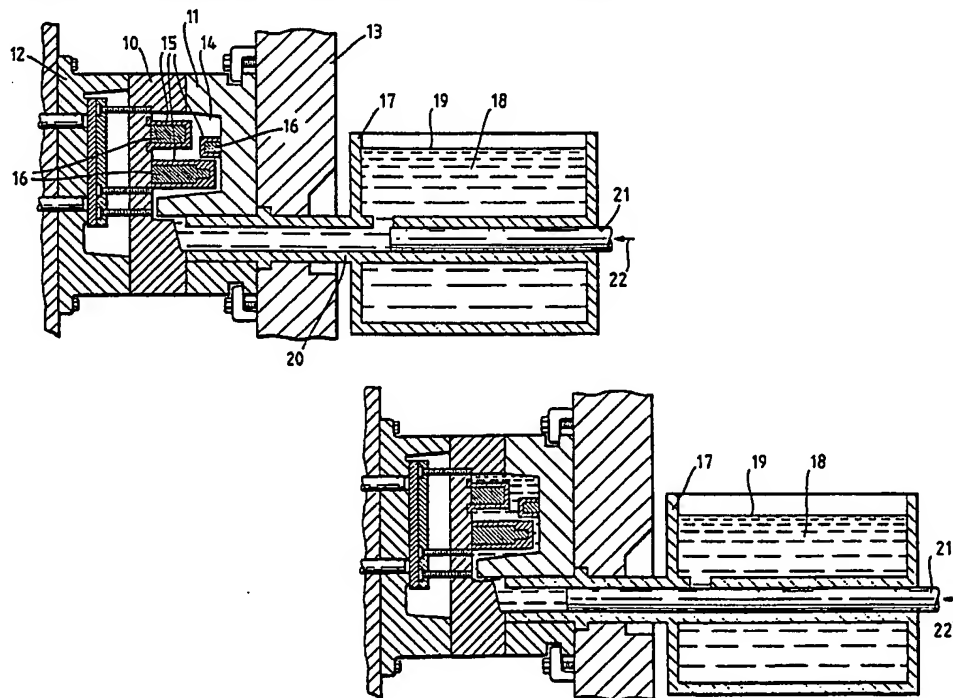
WORLD INTELLECTUAL PROPERTY ORGANIZATION  
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

<p>(51) International Patent Classification <sup>5</sup> : B23P 15/00, B22D 19/00 F15K 27/00</p>	<p>A1</p>	<p>(11) International Publication Number: WO 90/02017 (43) International Publication Date: 8 March 1990 (08.03.90)</p>
<p>(21) International Application Number: PCT/GB89/00956 (22) International Filing Date: 17 August 1989 (17.08.89) (30) Priority data: 8820550.5 31 August 1988 (31.08.88) GB (71) Applicant (for GB only): BRUNNER, Michael, John [GB/GB]; Cedarwood House, West Green, Barrington, Cambs. CB2 5SA (GB). (71) Applicant (for all designated States except US): KONGSBERG AUTOMOTIVE A/S [NO/NO]; P.O. Box 62, N-3601 Kongsberg (NO). (72) Inventor; and (75) Inventor/Applicant (for US only): SJØTUN, Kyrre, Guttorm [NO/NO]; Veungsdalsv. 15, N-3600 Kongsberg (NO).</p>		<p>(74) Agent: GILL JENNINGS &amp; EVERY; 53/64 Chancery Lane, London WC2A 1HN (GB). (81) Designated States: AT (European patent), AU, BE (European patent), BR, CH (European patent), DE (European patent), DK, FI, FR (European patent), GB, GB (European patent), IT (European patent), JP, LU (European patent), NL (European patent), NO, SE (European patent), US.  Published With international search report.</p>

(54) Title: METHOD OF MANUFACTURING VALVE ETC. HOUSINGS



(57) Abstract

A valve block or like housing is formed by the steps of cold forging a cylinder (15) and inserting the cold-forged cylinder in a mould (10, 11), after which molten metal is injection moulded around the cylinder to form the valve block or housing with the cylinder forming a valve cylinder.

***FOR THE PURPOSES OF INFORMATION ONLY***

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	ES	Spain	MG	Madagascar
AU	Australia	FI	Finland	ML	Mali
BB	Barbados	FR	France	MR	Mauritania
BE	Belgium	GA	Gabon	MW	Malawi
BF	Burkina Faso	GB	United Kingdom	NL	Netherlands
BG	Bulgaria	HU	Hungary	NO	Norway
BJ	Benin	IT	Italy	RO	Romania
BR	Brazil	JP	Japan	SD	Sudan
CA	Canada	KP	Democratic People's Republic of Korea	SE	Sweden
CF	Central African Republic	KR	Republic of Korea	SN	Senegal
CG	Congo	LI	Liechtenstein	SU	Soviet Union
CH	Switzerland	LK	Sri Lanka	TD	Chad
CM	Cameroon	LU	Luxembourg	TG	Togo
DE	Germany, Federal Republic of	MC	Monaco	US	United States of America
DK	Denmark				

DESCRIPTIONMETHOD OF MANUFACTURING VALVE ETC HOUSINGS

5           The present invention relates to the  
manufacture of valve housings, and particularly to  
the manufacture of valve housings which are formed  
within an alloy block, for example, multiple valve  
openings being located in a single block in order  
10 that fluid channels connecting the multiple valves  
can be connected without external fittings.

It is known to injection mould magnesium and  
similar alloys around cylindrical valve chambers  
which have been pre-formed by separate casting,  
15 reaming or drilling processes. Valve spools and the  
like, particularly those which are required to work  
axially, require the valve chamber to have a high  
degree of coaxiality and cylindricity whilst at the  
same time providing a surface macro-structure which  
20 has a high degree of smoothness. In order to produce  
such chambers by conventional methods, lengthy  
finishing processes are required such as honing or  
super-finishing. The manufacturing cost therefore of  
valve and like assemblies produced by such methods is  
25 extremely high. Furthermore, chambers formed by  
casting and then boring, reaming and finishing,  
result in a surface macro structure which has  
microscopic circular striations, resulting in  
undesirable tolerances between cylinder chamber and  
30 valve spool or piston.

Valve chambers in a block have been  
manufactured by the so-called "hot chamber" injection  
moulding process in which the material to be moulded  
is retained in a molten bath and is injected under  
35 pressure directly from the molten bath to the mould.  
Cylindrical chambers are formed by spigots in the  
mould around which the material is formed, but in

---

order to enable subsequent removal of the mould  
formers and spigots from the casting, it is necessary  
for the spigots to have a slight taper, in the order  
of 1°, so that chambers so formed require further  
5 finishing to achieve the desired degree of finish.  
Furthermore, working the surface of the cylindrical  
chamber cuts through the "casting skin" formed after  
the casting or moulding process and thus results in a  
chamber which, due to the microscopic porosity, of  
10 the casting, may not be absolutely fluid tight.

In order to overcome these problems and in  
accordance with the present invention therefore a  
valve or like housing is formed by the steps of cold  
forging a cylinder; and inserting the cold-forged  
15 cylinder in a mould and injection moulding around the  
cylinder to form a valve block or housing.

Preferably, the injection moulding process is a  
warm or hot chamber process as mentioned above, but  
it is envisaged that a cold chamber process, in which  
20 molten casting material is injected in a number of  
individual steps, may be used if desired. The  
advantage of the warm or hot chamber method is that  
it is considerably quicker and there are fewer  
impurities incorporated in the moulding or casting as  
25 a result of the multiple injection steps, since, in  
the warm or hot chamber method, the injection  
apparatus itself lies under the surface of the  
molten casting material.

A particular advantage of the method according  
30 to the invention, which is not achievable with other  
methods which involve casting around a pre-formed  
cylinder, is the negligible distortion of the  
cylinder and highly accurate location that can be  
achieved due to the high internal surface quality of  
35 the cylinder achieved by the cold forging step. A  
cold forged cylinder has a very high degree of

5        cylindricity and coaxiality and can thus be located on a locating spigot which is an extremely close sliding fit within the cylinder. This is just not possible with other methods where the cylinder is formed, for example, by a process which includes drilling, reaming etc. in which the surface finish is of lesser quality, resulting in less accurate fitting within the mould and the possibility therefore of distortion during the moulding process.

10        Additionally, a cold forged tube or cylinder has a surface macro-structure which extends in the axial direction to reduce friction and wear in a working valve spool or actuator sliding within the cylinder. Such cold forged cylinders have a  
15        considerably harder surface than that available with conventionally drilled and finished cylinders which increases the wear resistance of the surface. Furthermore, cold forged tubes or cups are not heated to the same degree during their initial manufacture  
20        and are therefore substantially free from internal stresses and tensions and thus relatively insensitive to temperature changes which, in other structures can lead to cracks and unsatisfactory finished products.

25        The speed of manufacture of blocks using the two stage process of the invention is considerably quicker than any producing comparable results that has hitherto been achievable, resulting in cheaper manufacturing costs. At the same time, cold forging offers the possibility of greater repeatability,  
30        better functioning due to reduced friction in use, and higher tolerances, resulting in better quality finished products.

35        One example of a method according to the present invention will now be described with reference to the accompanying drawings, in which:-

---

Figures 1, 2 and 3 show similar stages of three different cold forging processes used to produce cylindrical articles, any one of which may be appropriate for use in the process of the invention, depending upon the required structure of the valves in the valve housing; and,

Figure 4 shows a warm or hot chamber moulding process at two separate stages, schematically in sectional form.

Figure 1 shows in parts a, b and c respectively, three separate stages during the cold forging of a cylinder which may be used to provide a valve cylinder for a spool valve in a valve assembly in accordance with the present invention. Cold-forging techniques are, in themselves, well known and therefore the method shown in Figure 1 will not be described in detail. However, it should be noted that the cylinder 1 which is formed during the cold forging part of the process has a very high degree of cylindricity and internal surface smoothness, the cylinder being formed by the extrusion of the material of the cylinder (for example stainless steel or aluminium) by impacting a mandrel 2 onto the surface of the material from which the cylinder is to be formed, the material being held in a matrix 3. As the mandrel impacts and works the material, the cylinder 5 is formed coaxial with and closely spaced around the mandrel 2.

Figures 2 and 3 show the formation of cylinders of different cross-sections in order to illustrate the variety of different shaped cylinders that may be produced by the drop-forging process, in turn to illustrate the wide range of valve spool cylinder forms which may be employed.

Turning now to Figure 4, Figure 4a shows a warm chamber injection moulding process prior to injection of molton material, in this case magnesium, into a

mould, to form a valve block or housing.

As shown, the mould comprises mould halves 10,11 mounted on platens 12,13 as is conventional. A cavity 4 formed between the mould halves contains  
5 three valve spool cylinders 15, each of which is supported on a cylindrical spigot 16 so as to be accurately and firmly held in position within the mould cavity.

Each of the spigots 16 lies with its axis  
10 substantially parallel to the direction of opening and closing of the mould halves in order to enable the finished moulded product to be removed from the mould cavity at the end of the moulding process.

Each of the cylinders 15 is formed by a cold  
15 forging process such as that of Figures 1, 2 or 3 and the supporting spigot 16 in each case is formed so as to be an extremely accurate and close fit within the related cylinder, so that when the molten magnesium is injected (as will be described later) there is  
20 reduced possibility of movement or distortion of the cylinder. It is due to the cold forging of each of the cylinders that close tolerances can be achieved. As is shown in Figures 4(a) and 4(b) (top cylinder) the lip of the cylinder can be widened so as to  
25 locate positively in the opposite mould half and thus further prevent any possibility of movement during moulding-in.

The mould includes a bath 17 of molten magnesium 18 which extends to the mould cavity 14 via  
30 a cylinder 20 into which an injection ram 21 is rapidly moved back and forth (in the direction of arrow 22) in order to force the magnesium into the mould cavity and around the cylinders 15. This step is shown completed in Figure 4(b).

35 During injection, high pressures (around 50 Bar) are present in the mould and the high degree of cylindricity of the cylinders 15, in turn allowing a

very close fit on the spigots 16, serves to avoid or reduce any distortion or movement of the cylinders, thus providing highly accurate valve cylinder bores in the finished product, without the time consuming, and thus expensive, prior methods.

5 An advantage of using the so called warm or hot chamber injection moulding process is that dross and magnesium oxides which are formed at the surface 19 of the bath of molten magnesium, are this kept from entering the flow of magnesium to the mould thus  
10 reducing impurities and improving the quality of the casting. However, it is possible to employ a cold chamber injection moulding process as described above, but this is not shown in the drawings for the  
15 sake of simplicity. Both magnesium and aluminium alloys may be injection moulded in a cold chamber process, but the warm or hot chamber process is only presently capable of being used with magnesium  
20 alloys. A further advantage of the hot chamber process is the increase in production velocity, to the extent that between one and two hundred strokes per hour may be achieved in comparison with less than one hundred for a cold chamber process.

An additional advantage is found to lie in the  
25 fact that in the axial direction of the macrostructure the cold forging process also provides a so-called "closed" profile as opposed to an "open" process which is achieved in machining processes such as turning or drilling, so that valve spools fitted  
30 in the valve cylinders can be more effectively sealed therein.



CLAIMS

1. A method of forming a valve block or like housing comprising the steps of:
- 5 (a) cold forging a cylinder;
- (b) inserting the cold-forged cylinder into a mould; and
- (c) injection moulding metal around the cylinder to form a valve block or housing.
- 10 2. A method according to claim 1, wherein the injection moulding step is a warm or hot chamber process.
- 15 3. A method according to claim 1, wherein the injection moulding step is a cold chamber process, in which molten casting material is injected in a number of individual steps.
- 20 4. A method according to any of claims 1 to 3, wherein a plurality of cylinders are cold forged and inserted into a mould to form a plurality of valve chambers or like in a valve block.
- 25 5. A method according to any of claims 1 to 4, wherein the or each cylinder is supported in the mould on a spigot which is an accurate and close fit within the cylinder.
- 30 6. A valve block or like housing formed by the steps of cold forging a cylinder, inserting the cold-forged cylinder in a mould, and injection moulding around the cylinder to form a valve block or housing.
- 35 7. A valve block or like housing formed by the method of any of claims 1 to 5.
-

8. A valve block or like housing according to claim 6 or claim 7, wherein the cylinder is stainless steel or aluminium and the surrounding metal is a magnesium alloy.

5

10

15

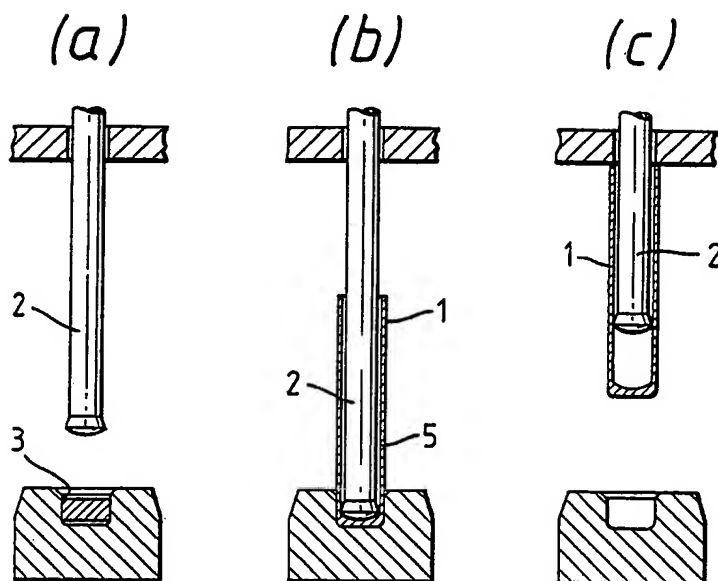
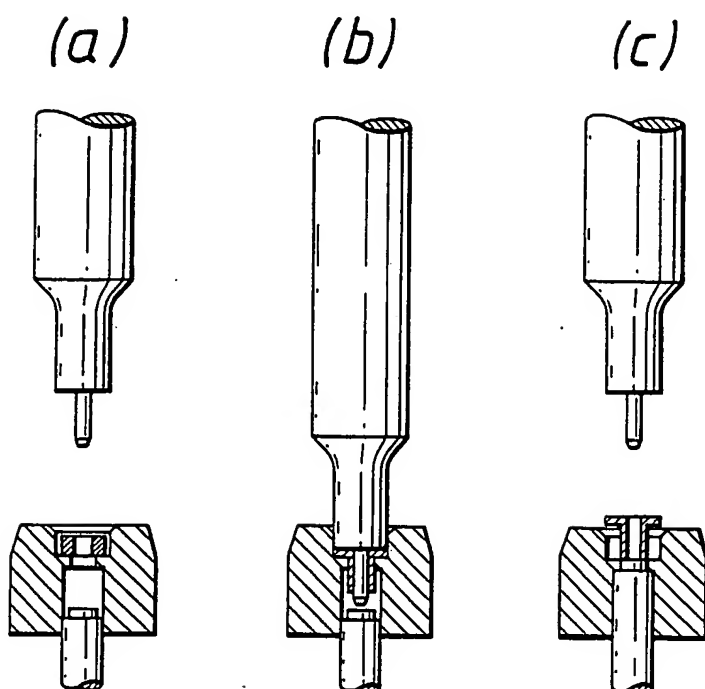
20

25

30

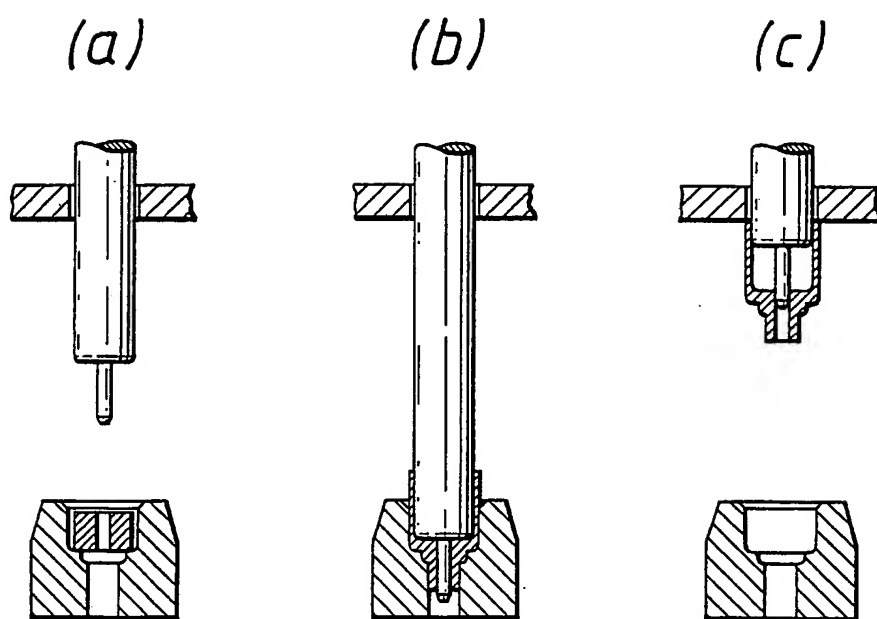
35

1/3

*Fig. 1.**Fig. 2.*

SUBSTITUTE SHEET

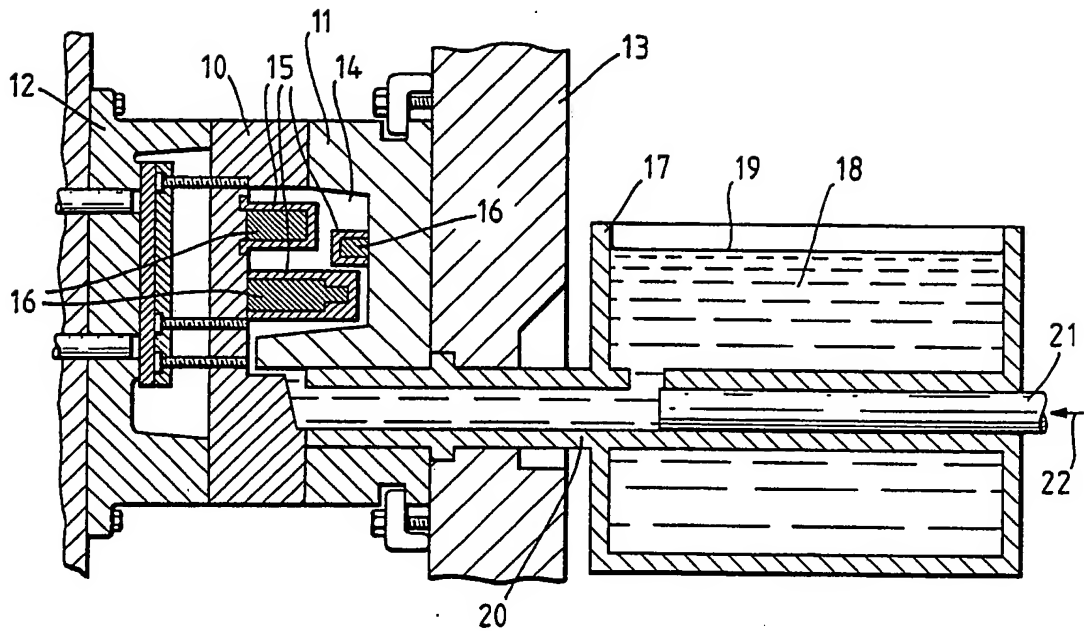
*Fig. 3.*



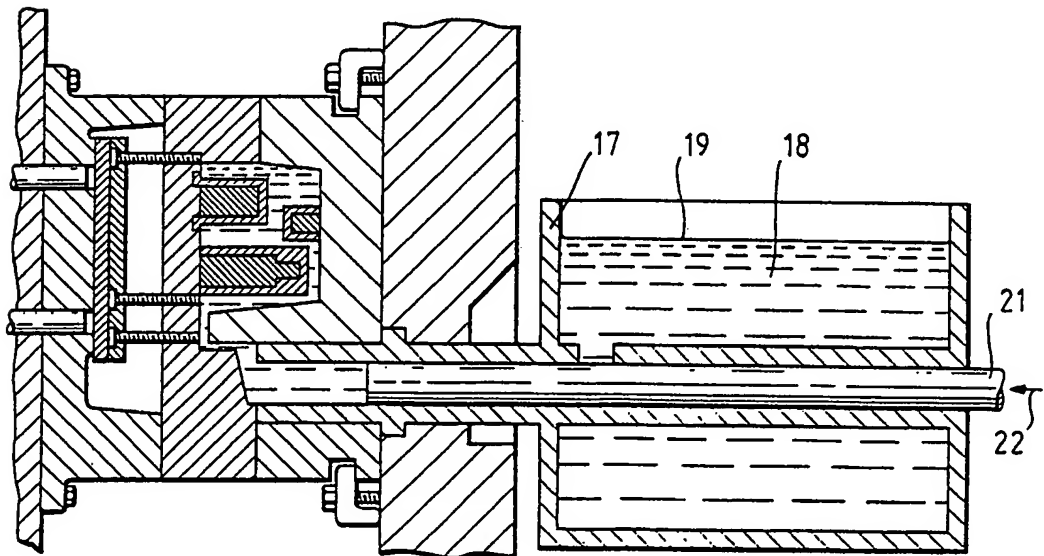
3/3

Fig. 4.

(a)



(b)



SUBSTITUTE SHEET

# INTERNATIONAL SEARCH REPORT

International Application No PCT/GB 89/00956

<b>I. CLASSIFICATION OF SUBJECT MATTER</b> (if several classification symbols apply, indicate all) <sup>6</sup>		
According to International Patent Classification (IPC) or to both National Classification and IPC		
IPC <sup>5</sup> : B 23 P 15/00, B 22 D 19/00, F 16 K 27/00		
<b>II. FIELDS SEARCHED</b>		
Minimum Documentation Searched <sup>7</sup>		
Classification System	Classification Symbols	
IPC <sup>5</sup>	B 23 P, B 22 D, F 16 K, B 60 T	
Documentation Searched other than Minimum Documentation to the extent that such Documents are included in the Fields Searched <sup>8</sup>		
<b>III. DOCUMENTS CONSIDERED TO BE RELEVANT</b> <sup>9</sup>		
Category <sup>9</sup>	Citation of Document, <sup>11</sup> with indication, where appropriate, of the relevant passages <sup>12</sup>	Relevant to Claim No. <sup>13</sup>
X	Patent Abstracts of Japan, vol. 8, no. 210 (M-328)(1647), 26 September 1984 & JP, A, 59097752 (HONDA GIKEN KOGYO K.K.) 5 June 1984, see the abstract	1-3,6,7
Y		4,5
A	--	8
Y	US, A, 3276082 (REYNOLDS) 4 October 1966, see figures	4,5
A	--	
A	US, A, 4516594 (DIESEL EQUIPMENT) 14 May 1985	1,6,7
A	--	
A	US, A, 4122596 (FORD) 31 October 1978	1,2,6,7,8
	----	
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><sup>10</sup> Special categories of cited documents:</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </div> <div style="width: 45%;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"A" document member of the same patent family</p> </div> </div>		
<b>IV. CERTIFICATION</b>		
Date of the Actual Completion of the International Search	Date of Mailing of this International Search Report	
4th December 1989	21 DEC 1989	
International Searching Authority	Signature of Authorized Officer	
EUROPEAN PATENT OFFICE	T.K. WILLIS	

**ANNEX TO THE INTERNATIONAL SEARCH REPORT  
ON INTERNATIONAL PATENT APPLICATION NO.**

GB 8900956  
SA 30912

This annex lists the patent family members relating to the patent documents cited in the above-mentioned international search report. The members are as contained in the European Patent Office EDP file on 12/12/89  
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US-A- 3276082		None	
US-A- 4516594	14-05-85	CA-A- 1236375	10-05-88
US-A- 4122596	31-10-78	None	